

Date: Monday, 12/01/2009 8:06:05 AM  
 User: Chantal Lavoie

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CUSHION  
 Job Number : 44543  
 Estimate Number : 13647  
 P.O. Number : Part Number : D3755041  
 This Issue : 12/01/2009 S.O. No. : Drawing Number : D3755 REV. B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : B  
 Previous Run : 43542 Material :  
 Written By : Due Date : 30/01/2009 Qty: 5 Um: Each  
 Checked & Approved By : C 20/01/12  
 Comment : Est: A 08.11.17 New issue EC verified by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



## Comment: PURCHASING

Issue P/O: 7942 C 20/01/12  
 Manufacture D3753-1 as per Dwg D3753  
 Material: Airflex fire-resistant aircraft cushioning, grade 30-40 (S)  
 layers to be laminated with silaprene DC12906 spray grade HPL contact adhesive  
 Possible Supplier: Chestnut Ridgefoam  
 Material release note is required

2.0 PACKAGING 1 PACKAGING RESOURCE #1



## Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage  
 Ensure Material Release Note is attached

3.0 QC6 DIMENSIONAL CHECK



## Comment: DIMENSIONAL CHECK

509102102 (S)

4.0 D38001200 Hook and Loop Strip (2" Soft)



## Comment: Qty.: 0.5250 f(s)/Unit Total: 2.6250 f(s)

Hook and Loop Strip (2" Soft) measured  
59123

Cut strip 6.00" long \*\*QTY 2\*\*\*

Batch: 13559

9/2/13

(S)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 8:06:05 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUSHION

Job Number: 44543

Part Number: D3755041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D38001100

Hook and Loop Strip (1" Soft)



2.6250 (1)  
44830



Comment: Qty.: 2.6250 f(s)/Unit Total : 13.1250 f(s)

Hook and Loop Strip (1" Soft)

Cut strip 30.00" long

Batch: 43558

6.0

D38003100

Hook and Loop Strip (1" Hard)



2.6250 (1)  
44831



Comment: Qty.: 2.6250 f(s)/Unit Total : 13.1250 f(s)

Hook and Loop Strip (1" Hard)

Cut strip 30.00" long

Batch: D43560

7.0

PG

PURCHASING



Comment: Issue P/O: 8116

Upholster as per Dwg D3755

Supplier: Lefebvre uphol

Ship: -Qty 1 D3753-1 seat cushion

-Qty 2 D3800-1-200-060 Loop strip

-Qty 1 D3800-1-100-300, Loop strip

-Qty 1 D3800-3-100-300, Loop strip

Material release note is required

C209102103

(3)

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Stores

09/03/02

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion


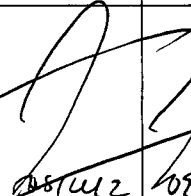



MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

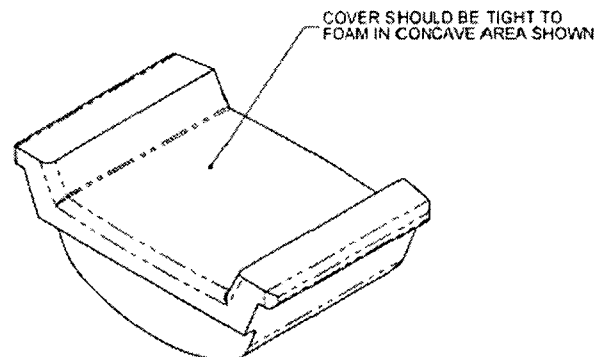
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-02-18	B.O	1 seat is missing the 6" velcro stitched to the back side, as per drawing. R.C.	 09/02/18	- Split w/o, and return the seat to the contractor to stitch on the velcro strips. - Have them supply a root cause description in writing.			 09/02/18	 09-02-19
				wrong w/o on the 03756-041 09-02-18				

NOTE: Date & initial all entries

# PARTS LIST

ITEM	QTY -041	QTY -1	P/N	DESCRIPTION
1	X		D3755-041	CUSHION
2	1	X	D3755-1	COVER
3	1		D3753-1	SEAT FOAM
4		2	D3800-1-200-060	LOOP STRIP
5		1	D3800-1-100-300	LOOP STRIP (CUT/FIT AS REQ'D)
6		1	D3800-3-100-300	HOOK STRIP (CUT/FIT AS REQ'D)
7		A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY MORBERN INC. P/N SY-111
8		A/R	THREAD	BONDED POLYESTER, 14.2 lb BREAK STRENGTH, GREY COLOR



**D3755-041 CUSHION**

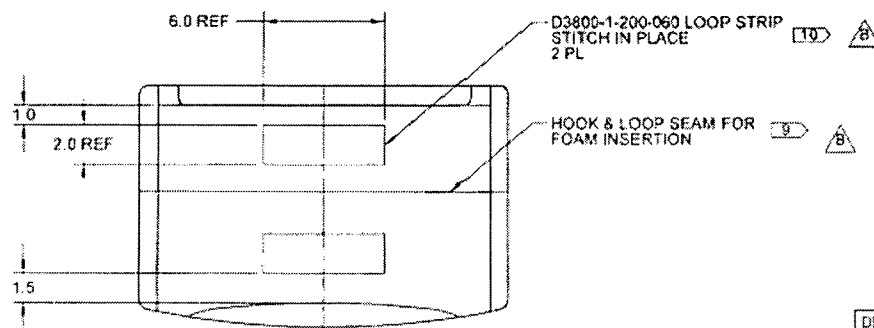
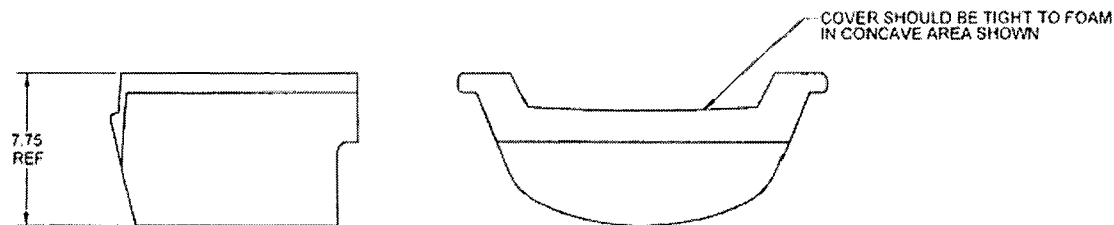
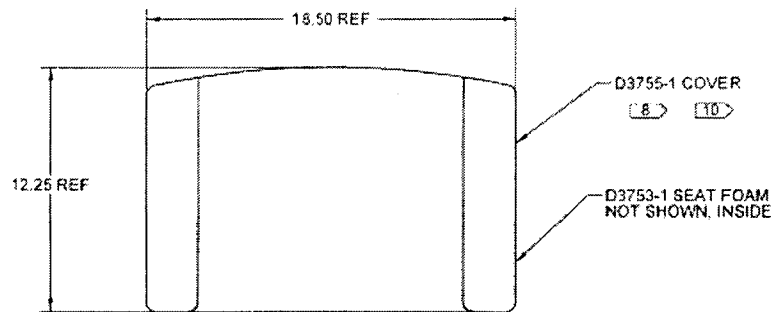
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WITHOUT NOTICE  
WORK ORDER  
NO. 44543

**RELEASED**  
06/11/05

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3755-041" USING LABEL
- 7) WEIGHT: 3.0 lbs
- 8) SEW D3755-1 COVER TO FIT D3753-1 FOAM
- 9) STITCH D3800-1-100-300 LOOP AND D3800-3-100-300 HOOK STRIPS ALONG EDGE OF SEAM TO CLOSE COVER. INSTALL THE HOOK STRIP ON THE TOP OVERLAPPING FLAP. INSTALL THE LOOP STRIP ON FABRIC NEXT TO FOAM
- 10) STITCHING: 4-6 STITCHES PER INCH. USE MIN 1/2" BACKSTITCH. NO LOOSE THREADS
- 11) CUSHION SHAPE / FORM / PATTERN TO CONFORM WITH TEMPLATE DT9419

0	COVER NOW CLOSED WITH SINGLE SEAM (ZN A3-1, B3-2). D3800-1-100-300 WAS D3800-1-100-500 (C8-1). D3800-3-100-300 WAS D3800-3-100-400 (D8-1). ORIENTATION OF D3800-1-200-060 CHANGED (B3-2). ADD ITEM NUMBERS TO PART LIST (B8-1)	CP	08 10 21
A	NEW ISSUE	CP	08 09 09
REV	DESCRIPTION	BY	DATE
DESIGN	97	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	97		
CHECKED	04	DRAWING NO.	REV B
MFG. APPR.	10	D3755	SHEET 1 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	10	CUSHION	NTS
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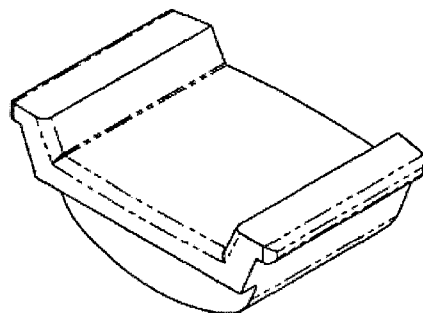


**D3755-041 SEAT CUSHION**

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NO. 44543

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08/10/05

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV B
MFG. APPR.		D3755	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION	NTS
DATE	08.10.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	



**D3753-1 SEAT FOAM**

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WORK ORDER  
NO. 44543

RELEASED  
08/11/09

**NOTES:**

- 1) MATERIAL: AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING  
GRADE 40-50 (COLOR: LIGHT YELLOW) LAMINATED TO GRADE 55-65 (COLOR: TAN)  
WITH SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE  
SUPPLIER: CHESTNUT RIDGE FOAM INC., P/N 503330-99
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3753-1" USING PERMANENT MARKER
- 7) WEIGHT: 2.5 lbs
- 8) FOAM SHAPE TO CONFORM WITH TEMPLATE DT8027

C	CHG SHAPE TO MATCH CHESTNUT SAMPLE: 5.68 WAS 5.65 (B8-2), 4.00 WAS 4.25 (B3-2), 1.25 WAS 1.00 (B3-2)	CP	08.10.08
B	FOAM SHORTER TO AVOID CYCLIC, 12.25 WAS 15.75 (C7-2), 5.85 WAS 6.10 (B6-2), FRONT PROFILE CHANGED (B3-2)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	<b>DART AEROSPACE LTD</b> HAYKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	PH	DRAWING NO. <b>D3753</b>	
MFG. APPR.	BE		
APPROVED	AP	TITLE <b>SEAT FOAM</b>	
DE APPR.	-H		
DATE	08.10.08	SCALE NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

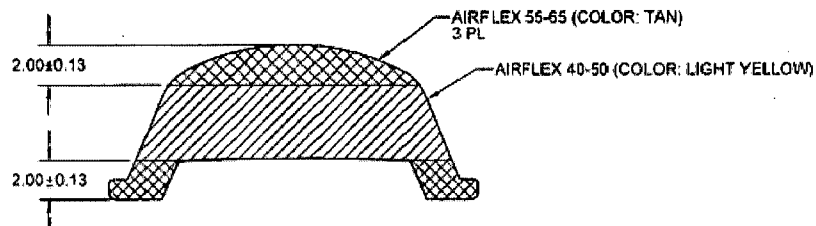
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

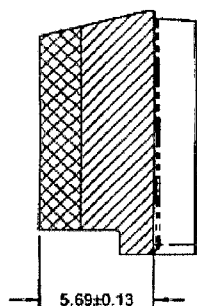
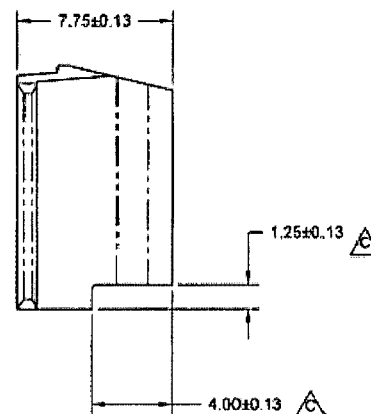
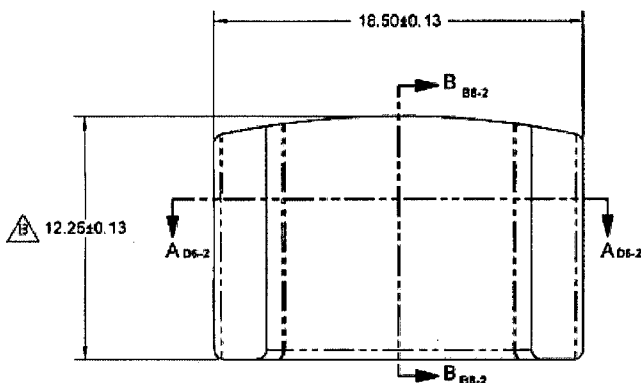
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

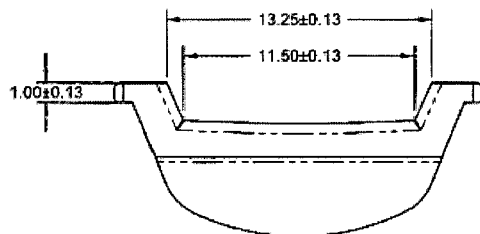




SECTION A-A C6-2



SECTION B-B C6-2



D3753-1 SEAT FOAM

RELEASED  
6/2/11/03

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WORK ORDER  
NO. 445-43-

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	94	DRAWING NO. D3753	REV. C
MFG. APPR.	94	SHEET 2 OF 2	
APPROVED	94	TITLE SEAT FOAM	SCALE NTS
DE APPR.	94	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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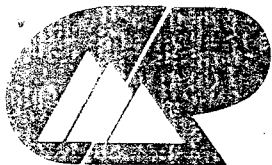
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Chestnut Ridge**  
Foam, Inc.

CERTIFICATE OF CONFORMANCE

SOLD TO:  
DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY  
ONTARIO, CANADA

K6A K7

PURCHASE ORDER: POC 0007942  
SALES ORDER: 340 9  
DATE SHIPPED: 01/13/09


**"URGENT! FLAMMABILITY CERTIFICATION  
ENCLOSED. PLEASE FORWARD TO  
PURCHASING. DO NOT THROW AWAY!"**

**I certify that the individual components comprising the part shipped  
against the above-reference purchase order meets the following  
requirements:**

14 CFR 25.853(a), APPENDIX F, PART 1(a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	Part Number	Material	Batch Number
5	D3753-1	503330-99	AIRFLEX40-50 AIRFLEX55-65	AF9003 AF8056
5	D3754-1	603150-99	AIRFLEX30-40	AF9001

MADE IN THE U.S.A



Mark A. Brown  
Technical Director



**CHESTNUT RIDGE FOAM INC.**  
**VERTICAL BURN TEST # 11410**  
**12-SECOND VERTICAL BUNSEN BURNER TEST**  
**FOR CABIN AND CARGO COMPARTMENT MATERIALS**  
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : AIRFLEX  
BATCH / LOT NO : AF9003  
CUSTOMER : PRODUCTION  
P.O. NO :  
OTHER IDENTIFICATION : AFX 40-5

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : YELLOW

FLAME TEMPERATURE : 1553°F

CONDITIONING STARTED : DATE 1-22-09  
TIME 7:30 AM

TEST STARTED : DATE 1-23-09  
TIME 1:05 PM

**RESULTS :**

	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	5.9
#2.	0.0	0.0	5.4
#3.	0.0	0.0	6.0
AVG.	0.0	0.0	5.8

PASS : X      FAIL :

**COMMENTS :**

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,  
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : KEN SPILLAI  
LAB TECHNICIAN

*[Signature]*

**CHESTNUT RIDGE FOAM INC.**  
**VERTICAL BURN TEST # 11380**  
**12-SECOND VERTICAL BUNSEN BURNER TEST**  
**FOR CABIN AND CARGO COMPARTMENT MATERIALS**  
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : AIRFLEX  
BATCH / LOT NO : AF8056  
CUSTOMER : PRODUCTION  
P.O. NO :  
OTHER IDENTIFICATION : AFX 55-6

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : ORANGE

FLAME TEMPERATURE : 1557°F

CONDITIONING STARTED : DATE : 12-22-08  
TIME : 8:00 AM

TEST STARTED : DATE : 12-24-08  
TIME : 7:10 AM

**RESULTS :**

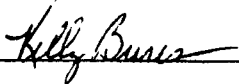
	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	1.1	0.0	6.2
#2.	1.0	0.0	6.6
#3.	0.5	0.0	7.0
AVG.	0.9	0.0	6.6

PASS : X      FAIL :

**COMMENTS :**

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,  
PARAGRAPH (a) AND APPENDIX F, PART , (a), (1), (ii).

TESTED BY : KELLY BURES  
SR. LAB TECHNICIAN



**LEFEBVRE'S UPHOLSTERY**

PO BOX 1965  
CORNWALL, ON  
K6H 6N7

**Invoice**

Date	Invoice #
11/02/2009	3410

Bill To
DART AEROSPACE LTD 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7

Ship To
DART AEROSPACE LTD 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7

P.O. No.	Terms	Rep	Ship	Via	F.O.B.
PO00008116	Due on Receipt	LP	11/02/2009	Courier	CORNWALL
Quantity	Item	Description		Price Each	Amount
5	SET	COVERS D3755-041 AS PER SPECS COVERS D3756-041  SURREY VINYL 111 SILVER SUNSET  PACKING SLIP: 645348 FEB. 5 - 2009  THREAD BONDED POLYESTER UTILIZED  Numéro d'entreprise : 885239855		0.00	0.00T
Subtotal				\$0.00	

GST	\$0.00
PST	\$0.00
<b>Total</b>	\$0.00
<b>Payments/Credits</b>	\$0.00
<b>Balance Due</b>	\$0.00

Phone #	Fax #	E-mail
613-938-3046	866-449-5408	globaltrends@myibocs.com

# Surrey

FROM THE DEFENSE FINISH COLLECTION

## Specifications

- Nominal total thickness: .044 ± .045 inches (44 ± 4.5 mils)
- Standard weight: 30.75 ± 1.5 ounces per linear yard
- Abrasion resistance: No significant wear after 200,000 double rubs with #8 cotton duck using the Wyzenbeek test method
- Anti-Bacterial/Anti-Microbial treatments
- -25° F cold crack resistance
- Anti-static finish
- Sulfide stain resistant
- Oil resistant
- Width: 54 inches
- Roll length: 40 yards

## Flame Resistance

Manufactured to meet the following flammability\* requirements

- Port Authorities of New York and New Jersey
- CID-A-A-2950-A (Formerly CCC-A-680a)
- Federal Standard 191A Test Method 5903.1
- Federal Specification CCC-A-700J
- FAA Regulation 25.853 (a) and Appendix F, Part 1 (a) (i) (ii)
- NFPA 701-89 and 701-99 Small Scale Test
- FMVSS 302
- California Flammability Regulation (Bulletin 117, Section E)
- BIFMA Class A
- UFAC Class 1

- \* This term and all corresponding data refer to typical performance in the specific test indicated and should not be construed to imply the behavior of this or any other material under actual fire conditions.

## Care and Cleaning Instructions

It is recommended that each stain is cleaned in a stepwise manner using the sequence below.

- Step 1: Regular cleaning (dirt and grime): Use mild soap and water, then fresh water rinse. Cleaning frequency depends on use. As a minimum, please clean weekly.
- Step 2: Stubborn stains (crayon, eye shadow, chocolate, blood): Wipe using a soft cloth or soft brush. Use detergent cleaners such as Formula 409 or Fantastik. Rinse with clean water and wipe dry.
- Step 3:\*\* More difficult stains (ballpoint pen, lipstick, mustard, tar or asphalt): Carefully clean the stained area with lighter fluid or rubbing alcohol. Carefully rinse with clean water and dry. Note: For best results, immediate attention is required for severe stains.

- \*\* Caution: Exercise care as these solvents are flammable. Use only small quantities of solvents and keep clear of any sources of ignition. Wear protective gloves and ensure cleaning takes place in a well ventilated area.

MELLOHIDE